

Work Order ID 71374

Thursday, June 30, 2011 10:24:02 AM



Page 1

Item ID:	D2574	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, Aft In 205					
Start Date:	6/30/2011	Start Qty:	12.00	Cust Item ID:		
Required Date:	7/15/2011	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>H</u>	Date:	<u>11-06-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2574	Rev E								

100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>71374</u> Double check by: _____ <input type="checkbox"/> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets <input type="checkbox"/> 3-Machine Step No 3 per Folio FA051 and insp			<u>and 11/07/12</u>		<u>10</u>	<u>0</u>		

110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2573 & D2574			<u>and 11/07/12</u>		<u>10</u>	<u>0</u>		

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control				<u>and 11/07/12</u>		<u>10</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71374

Thursday, June 30, 2011 10:24:02 AM



Page 3

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 6/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 d 11/10/19

170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

11/7/19 102/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20 MF 11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 10:24:08 AM

Page 1

Work Order ID: 71374

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205


Start Date: 6/30/2011

Required Date: 7/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			110	Each	49.0000	1	12			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT045	38	
66966	18	
→ 70676	20	
MAT046	11	
65382	4	
65953	4	
66966	3	

10
ml 11/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71374
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.501	.501	.502	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.502	.501		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.568	.568	.568	.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.500	2.500	2.499		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		.124	.124	.126	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.257	.252	.250		
S	0.115	0.135		.127	.127	.126	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.227	3.230		
V	0.230	0.250		.238	.238	.238	.239		
W	0.115	0.135		.124	.121	.121	.123		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.363	.362	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.246	.247	.247		
AE	1.500	1.520		1.510	1.510	1.512	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.248	.250	.248	.249		
AI	2.000	2.020		2.003	2.003	2.005	2.003		
AJ	0.023	0.043		.033	.033	.033	.030		
Accept/Reject									

Measured by:	cmf
Date:	11/07/12

Audited by:	A.A
Date:	11/07/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71374
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.502	.504	.502	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.501	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.568	.569	.568	.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.123	4.122	4.122	4.122		
P	0.115	0.135		.125	.125	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.257	.257	.257		
S	0.115	0.135		.126	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.227	3.229		
V	0.230	0.250		.239	.239	.238	.237		
W	0.115	0.135		.125	.125	.124	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.761		
Z	0.352	0.372		.365	.364	.366	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.246		
AE	1.500	1.520		1.509	1.510	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.249	.249	.247	.247		
AI	2.000	2.020		2.003	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	amp
Date:	11/07/14

Audited by:	B.A
Date:	11/07/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 71374
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.004				
F	0.490	0.510		.502	.503				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.501				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.568	.569				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.368	1.368				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.123				
P	0.115	0.135		.124	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.257				
S	0.115	0.135		.126	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.229				
V	0.230	0.250		.239	.238				
W	0.115	0.135		.124	.125				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.761	.761				
Z	0.352	0.372		.364	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.247	.247				
AE	1.500	1.520		1.509	1.509				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.275	.275				
AH	0.240	0.260		.249	.249				
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>B. n</i>
Date: 11/07/14	Date: 11/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

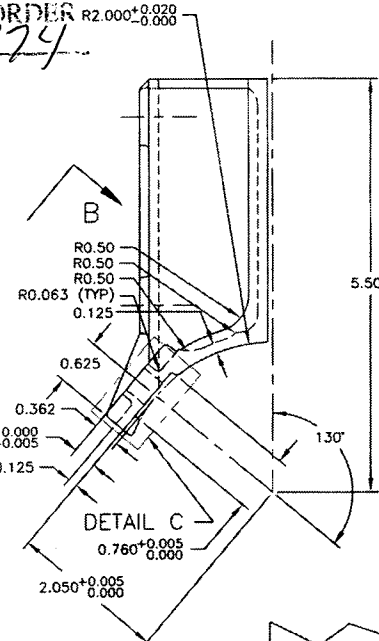
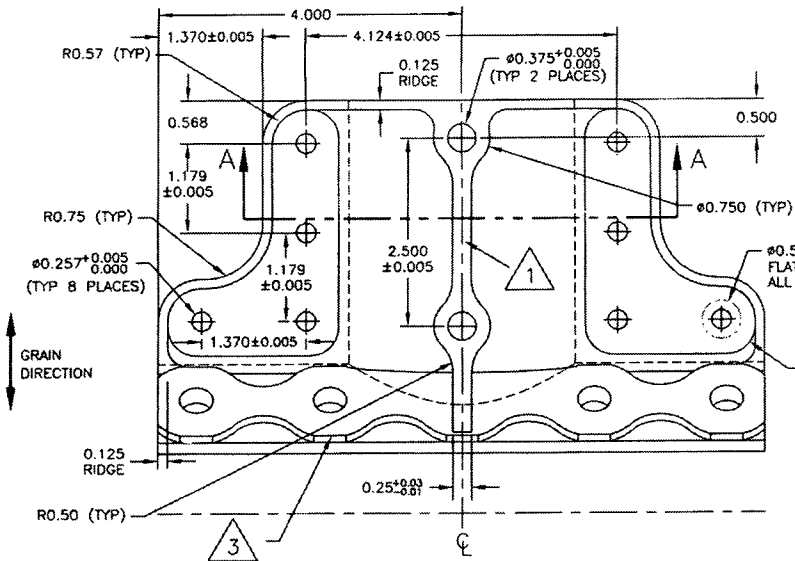
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 71374

RELEASED

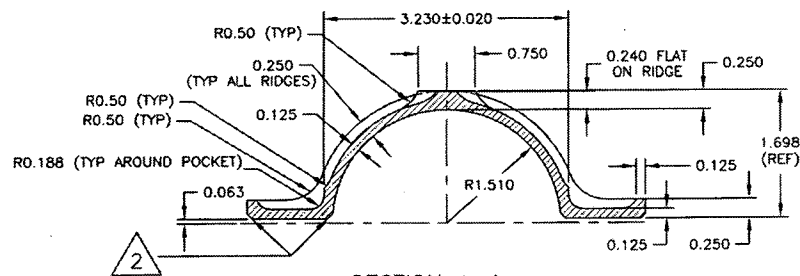
05.12.06



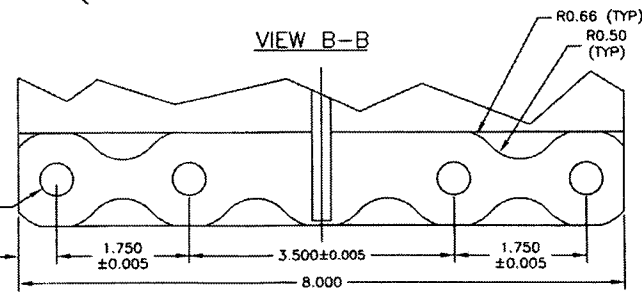
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

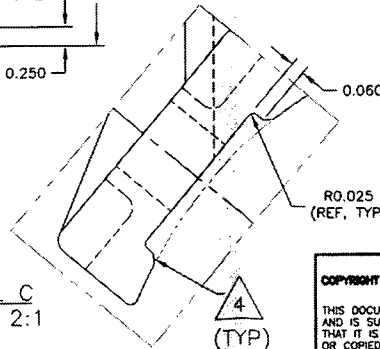
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

COPYRIGHT © 2005 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. E
CHECKED H	APPROVED H	DRAWING NO. D2574	SHEET 1 OF 1
DATE 05.07.13	TITLE INNER AFT SADDLE	SCALE 2:3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries